



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3312

Job Sheet 200365



Part No: 646.3312

Job Qty: 12 pcs

Part Name: Center Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12/11/16 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 ²⁰ pcs	10/15/19	10/15/19	0.00	0.09	Bandsaw - 1		SBL 19/10/12
110	HAAS 4 Axis - B4B	12 ²⁰ pcs	10/15/19	10/15/19	0.29	8.98	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/10/12
							HAAS - 4 - B4B		
120	QC 1	12 ²⁰ pcs	10/15/19	10/15/19	0.00	0.00	QC 1 - 14		
							QC 1 - 35		SBL 19/10/12
							QC 1 - 8		
							QC 1 - 9		
130	QC 8	12 ²⁰ pcs	10/15/19	10/15/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		ML 19/10/13
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		



Container No: S222136



Part: 646.3312

Job No: 200365

Serial No/Batch: S222136

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/12/19

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				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
140	Outsource - 4 - Anodize	1220 pcs	10/15/19	ATG001-VC	8
150	Packaging 2-1 - Receive - B4B	1220 pcs	10/15/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B

2019-10-15

NOV 05 2019

155 QC 5	12 20 pcs	10/15/19	0.00 0.00	Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS DEC 06 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Packaging 3-1 - Stock - B4B	12 20 pcs	10/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	DAS 74 DEC 09 2019
				Packaging 3 - 5 - B4B	9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
190 QC 21 - SA	12 pcs	10/15/19	0.00 0.00	QC 21 - SA - 70	
				QC 21 - SA - 53	
					DEC 09 2019

Part Op 100 - Cut Blank at 16.300" *** ONE BLANK MAKES TWO PARTS***

Descriptions: 110 - 1-Machine per folio FB153 3-Face to .375" if required

120 - (QC1- Inspection performed by CMM) Inspect on CMM as per folio CMM027.

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : 44771 Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S0.375X5.000	M7075T6S0.375 X 5.000	8.1600 ft (.68 ea)	100-Bandsaw - 1	S175773

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S0.375X5.000	8	29	0

S175773x69.125 Stripper

S175773x96.25 -> Stripper

S175773x ~~96.25~~ 96.32 -> 80 po = 16.300 used

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Center Plate	0.177inches $\pm$ 0.002	0.179 0.175	Diameter	pin gage
2	Center Plate	0.209inches $\pm$ 0.002	0.211 0.207	Diameter	pin gage
3	Center Plate	0.125inches $\pm$ 0.005	0.130 0.120	Radius	Rad. gage
4	Center Plate	0.313inches $\pm$ 0.002	0.315 0.311		
5	Center Plate	2.156inches $\pm$ 0.002	2.158 2.154		
6	Center Plate	1.410inches $\pm$ 0.002	1.412 1.408		
7	Center Plate	2.737inches $\pm$ 0.005	2.742 2.732		
8	Center Plate	1.537inches $\pm$ 0.005	1.542 1.532		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER

POHB044771



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: POHB044771
PO Date: 10/15/19
Due Date: 10/29/19

Purchase Order Revision:
Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dataero.com

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Price (CAD)	Unit	Extended Price
1	200356	646/2910	646.2900 Rev N/C	Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed -		10/29/19	12 pcs	0 pcs	12 pcs	\$48.74/pcs		\$584.88
				Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C									
2	201250	D4703-043	D4703 Rev B	Lock Pin Base : Various STC's Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -As Per Dwg D4703 -Material type: 6061T6 -Certificate of Conformity is required	Firmed -		10/29/19	10 pcs	0 pcs	10 pcs	\$34.44/pcs		\$34.40

X/O

NOV 05 2019

DP

NOV 05 2019

X10



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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	198841	D4842-4	D4842 Rev B	Lower Cutter Body, RH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A- 8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P- 23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005, C OF C IS REQUIRED	Firmed -		10/29/19	16 pcs	0 pcs	16 pcs	\$10.99/pcs	\$175.84
				X16				NOV 0 5 2019				DP
4	198840	D4842-3	D4842 RevB	Lower Cutter Body, LH Issue P/O : AS PER DWG D4842 HARD ANODIZE IAW MIL-A- 8625 TYPE III, CLASS 2, COLOR BLACK, PRIME IAW MIL-P- 23377 J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005, C OF C IS REQUIRED	Firmed -		10/29/19	16 pcs	0 pcs	16 pcs	\$10.99/pcs	\$175.84
				X16				NOV 0 5 2019				DP
5	200585	646.3210	646.3200 Rev NC	Support : Various STC's Issue P/O to ATG : 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed -		10/29/19	20 pcs	0 pcs	20 pcs	\$15.09/pcs	\$301.80
				X20				NOV 0 5 2019				DP
6	197033	649.4813	649.4800 Rev E	Shim : Various STC's Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1)ISSUE P/O: As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A- 8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P- 23377J Type1 Class N	Firmed -		10/29/19	26 pcs	0 pcs	26 pcs	\$6.99/pcs	\$181.74
				X26				NOV 0 5 2019				DP
7	200990	646.3712	646.3700 Rev A	Clip : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg 646.3712 Rev. A	Firmed -		10/29/19	25 pcs	0 pcs	25 pcs	\$6.84/pcs	\$171.00
				X25 pcs				NOV 0 5 2019				DP



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PURCHASE ORDER

POHB044771



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	200588	646.3711	646.3700 Rev A	Clip : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3700 Rev. A	Firmed	-	10/29/19	24 pcs	0 pcs	24 pcs	\$6.84/pcs	\$164.16
								X24				NOV 05 2019
9	200365	646.3312	646.3300 Rev A	Center Plate : Various STC's Issue P/O to ATG : Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C	Firmed	-	10/29/19	20 pcs	0 pcs	20 pcs	\$12.79/pcs	\$255.80
								X20				NOV 05 2019

Grand Total: \$2,045.46

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/28/19 8:35 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918894

Date: 04-Nov-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
20 ea	Part: 646.3312 Center Plate Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 26321 PO: POHB044771		
	Rev: A Expiry Date: 06/20 Line: 9		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>NOV 04 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

RECEIVED
NOV 04 2019
DART AEROSPACE LTD.

Made in Canada.